



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PRELIMINARY ISSUE

650.9610

Job Sheet 211097



POSITIVE
RECALL

POSITIVE
RECALL

Part No: 650.9610

Job Qty: 5 pcs

Part Name: Electric Valve Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/3/20

Job Tracking No:

Due Date: 7/15/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 650.9600 REV PB1 IPP REV A 20.06.24 NEW ISSUE FK VERIFY DD

Ship Via:

139 Valve

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
100	SL-2500Y - 1	5 pcs	7/7/20	7/7/20	1.00	1.67	SL-2500Y - 1	
110	QC 2	5 pcs	7/7/20	7/7/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	



Container No: S290140



Part: 650.9610

Job No: 211097

Serial No/Batch: S290140

Revision: REV - PB1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/20/20

P.T.O.

					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
112	HAAS 5 Axis - B4B	5 pcs	7/8/20	0.75 10.00	HAAS - 1 - 5 - B4B	
					HAAS - 2 - 5 - B4B	
114	QC 2	5 pcs	7/8/20	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
120	QC 8	5 pcs	7/8/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	

					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 81	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
130	Outsource - 17 - Passivate	5 pcs	7/15/20		GRO002-VC	5
140	Packaging 2-1 - Receive - B4B	5 pcs	7/15/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 37 - B4B	
150	QC 6	5 pcs	7/15/20	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
					QC 6 - 82	
160	Packaging 3-1 - Stock - B4B	5 pcs	7/15/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	



				Packaging 3 - 8 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	5 pcs	7/15/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	

Part Op 100 - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1-Machine as per folio FD318 FOLIO REV:
 Descriptions: AA DWG REV: BS 2-Debur

110 - QC2- Inspect parts off machine FAI/FAIB

112 - ***CRITICAL PART - EXTREME CARE MUST BE TAKEN*** 1-Machine as per folio FD318 FOLIO REV:
 DWG REV: _____ 2-Debur

120 - QC8- Inspect parts - second check

130 - -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of
 Conformity is required

140 - Certificate of Conformity is required

150 - QC6- All purchased or subcontracted products

160 - Identify as per dwg & Stock

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.750	303 Round Bar 2.750"	5 ft (1 ea)	100-SL-2500Y - 1	S 289 696

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-SL-2500Y - 1	M303R2.750	5	0	0

Part Specifications

Specifications could not be found.

Plex 7/3/20 11:44 AM Dart.lajeunesse.marie

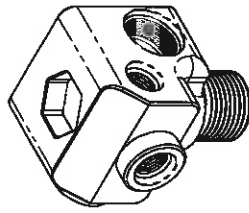
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF DART AEROSPACE DBA APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE DBA APICAL INDUSTRIES IS PROHIBITED.

NOTES:

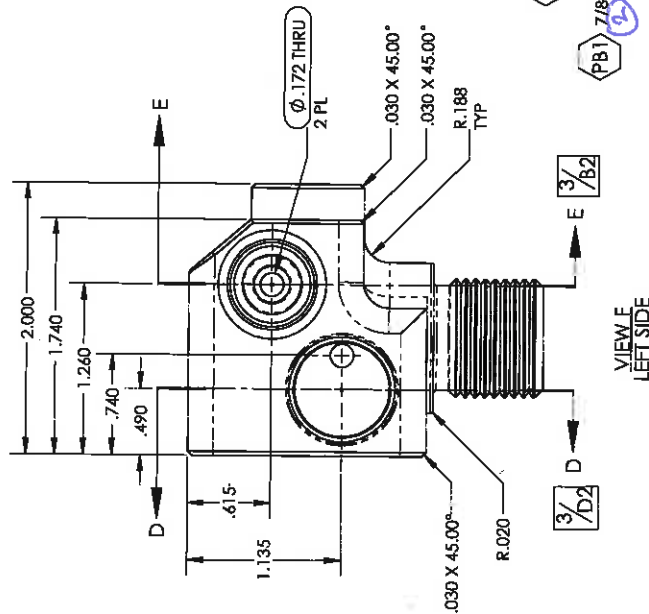
- 1 MATERIAL: 303 SS IAW AMS-5640
- 2 DEBURR AND BREAK ALL SHARP EDGES
- 3 IDENTIFY IAW MPP-120
- 4 USE THREAD SIZE 3/4-28 UNF-2B
- 5 FINISH $\sqrt{25}$ MAX UNLESS OTHERWISE SPECIFIED
- 6 ALL THREAD DEPTHS ARE MINIMUM
- 7 (PB) FINISH: PASSIVATE IAW MPP-172 SECTION 6.1.

PROTOTYPE REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED
ALL		REMOVED ±.005 TOLERANCE		
B1-1		REMOVED ELECTROPOLISH FINISH		
C1-1		ADDED .015-.031 DIMENSION		
C6-1		ADDED SURFACE ROUGHNESS VALUE		
C7-1		ADDED R.005-.020 DIMENSION		
C8-1		DIMENSION WAS .114 B. 107+.015/- .000		
D1-1		THREAD CLASS WAS 2A IS 3A		
D2-1		ADDED .250 Z PL DIMENSION		
B1-2		ADDED .250 Z PL DIMENSION		
	PB1	DIMENSION WAS 0.7350 DIMS. 0.734-.002/- .003	06/01/2020	T. CROSS
		ADDED SURFACE ROUGHNESS VALUE		
C5-2		DIMENSION WAS 0.300±.045 IS 0.300±.006/- .001		
D1-2		ADDED ALL AROUND TO DIMENSION		
D2-2		ADDED R.010 Z PL DIMENSION		
B4-3		DIMENSION WAS 0.089 DIMENSION		
B5-3		ADDED SURFACE ROUGHNESS VALUE		
B6-3		ADDED .084-.089 DIMENSION		
		DIMENSION WAS 0.050 ± .002 IS .050-.054		
		ADDED SURFACE ROUGHNESS VALUES		
		ADDED SURFACE ROUGHNESS VALUE		
B7-3				

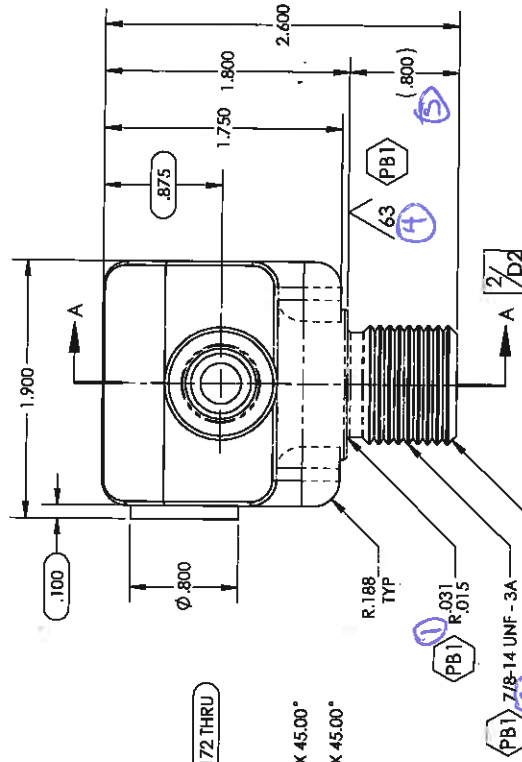
REV.	DESCRIPTION	DATE	APPROVED
N/C	INITIAL RELEASE	04/04/15	P. BRAVO
A	INCORPORATED FOR REV15	07/14/15	P. BRAVO
B	INCORPORATED FOR 0004	04/12/16	P. BRAVO



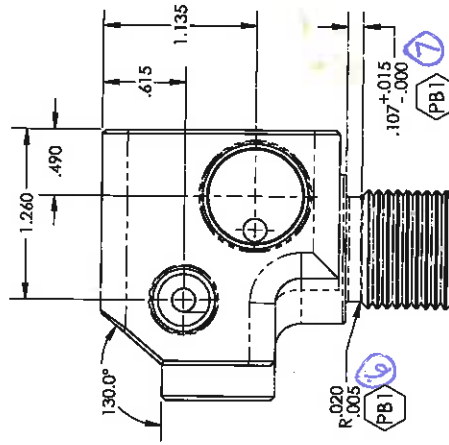
650.9610



VIEW F
LEFT SIDE



VIEW A
FRONT



VIEW B
RIGHT SIDE

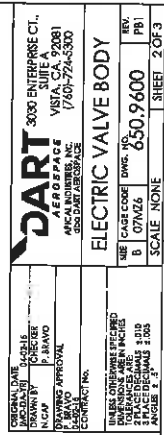
[illegible]

32
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTICE

WORK ORDER
NO. 211097 MLS

2007-03

7



66



1/D2



16



PORT PER-
SAE J1926-4
UNLESS
OTHERWISE
SPECIFIED



△ 4 PORT PER-
SAE J1926-8
UNLESS
OTHERWISE
SPECIFIED



 DART AEROSPACE 10000 AIRPORT BLVD AUSTIN, TEXAS 78717-5000 (512) 835-8000	3000 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 724-5500
ELECTRIC VALVE BODY	
REE: CAGE CODE 0000, NO. 0000 B1 0704M6 SCALE NONE SHEET 3 OF 3	REV. 1 P81

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: <u>211 097</u>		DEPARTMENT/PROCESS		Engineering	
Part No. <u>650-9610</u>		Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☒ Finishing ☐ Rec/Store/Packaging ☐		Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>20-08-13</u>	Sequence #: <u>110</u>	QTY Affected: <u>5</u>		MRB (QSI042) DAS 9 9-89 <u>20-8-13</u>	
Description Work Order Deviation		Disposition			
Blanks were cut to short as a result of what the w.o. demanded. Can not machine. cut at 3.000" needed to be cut at 3.300"		feed program to be updated 20-08-13			
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Power Loss/Surge ☐ Misaligned/off center ☐ Folio/Program ☒ BOM/Route ☐ Grain Direction ☐ Broken/Damage/Defect ☐ Weld ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Drill Holes ☐ Out of Sequence ☐ Fit/Function ☐ Off-set/Set-up ☐			
Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details:					
Lead hand / Supervisor		QC / QA Coordinator			
		DAS 9 9-89 <u>20-8-13</u> DAS 9 9-89 <u>20-8-13</u>			

